



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3205-00T

Job Sheet 197351



Part No: RBE350A93-3205-00T

Job Qty: 15 pcs ^{1/6} ^{DAS 21} ⁹⁻⁰⁸

Part Name: Tail Rotor Gear Box Input Flange Holding Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3205-00T Rev 3C IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	15 pcs	9/2/19	9/2/19	0.17	1.50	Waterjet - Omax		2019/10/24
110	QC 2	15 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2019/10/24
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Plex 7/4/19 3:21 PM Dart.lajeunesse.marie

					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
					NV5000 - 1 - B4B	ALA./J.C.C.	19-10-20
120	NV5000 - 2 - B4B	15 pcs	9/2/19	1.00 3.75	NV5000 - 2 - B4B		
130	QC 2	15 pcs	9/2/19	0.00 0.00	QC 2 - 1		
					QC 2 - 12		
					QC 2 - 14	ALA/ J.C.C.	19-10-20
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23	V	
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
140	QC 8	15 pcs	9/2/19	0.00 0.00	QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8		
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	WKS 19/10/30
					QC 8 - 57	
170	Outsource - 4 - Anodize	15 pcs	9/2/19		ATG001-VC	10 2019-11-04
180	Packaging 2-1 - Receive - B4B	15 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190	QC 6	15 pcs	9/2/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
200	Small Fab - 2 - B4B	15 pcs	9/2/19	0.00 1.25	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
205	QC 5	15 pcs	9/2/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	

NOV 15 2019

DAS
JAN 02 2020
68
9-89

EP 20-01-63.

					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
206	Packaging 3-1 - Stock - B4B	15 pcs	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - FG	15 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	
Part Op 100 - OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: <u>3C</u> Prog Rev: <u>3C</u> ***Holes finished size only rest will Descriptions: be machined to finished size*** 2-Deburr if necessary 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio FB744 FOLIO REV: <u>AA</u> DWG REV: <u>3C</u> 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 170 - Issue P/O to ATG: <u>44992</u> -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C 180 - (Receive & Inspect for Damage & Mat'l Certs)						

- 190** - (QC6- All purchased or subcontracted products)
200 - (Small Fab) Pick, bag and tag
205 - (QC5- Inspect part completeness to step on W/O)
206 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	5.2500 sf (.35 ea)	100-Waterjet - Omax - 1	5138977
AN315-5R	Nut 5/16-24 OVER 007	45 Ea (3 ea)	200-Small Fab - 2 - B4B	084127
AN5-7	Hex Head Cap Screw 5/16-24	45 Ea (3 ea)	200-Small Fab - 2 - B4B	5084124 x2 1010 5x46
NAS1149F0563P	Washer (AN960-516) GA200	45 Ea (3 ea)	200-Small Fab - 2 - B4B	217719.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M6061T6S.250	5	55	0
200-Small Fab - 2 - B4B	AN315-5R	45	203	0
	AN5-7	45	47	0
	NAS1149F0563P	45	211	0

Part Specifications

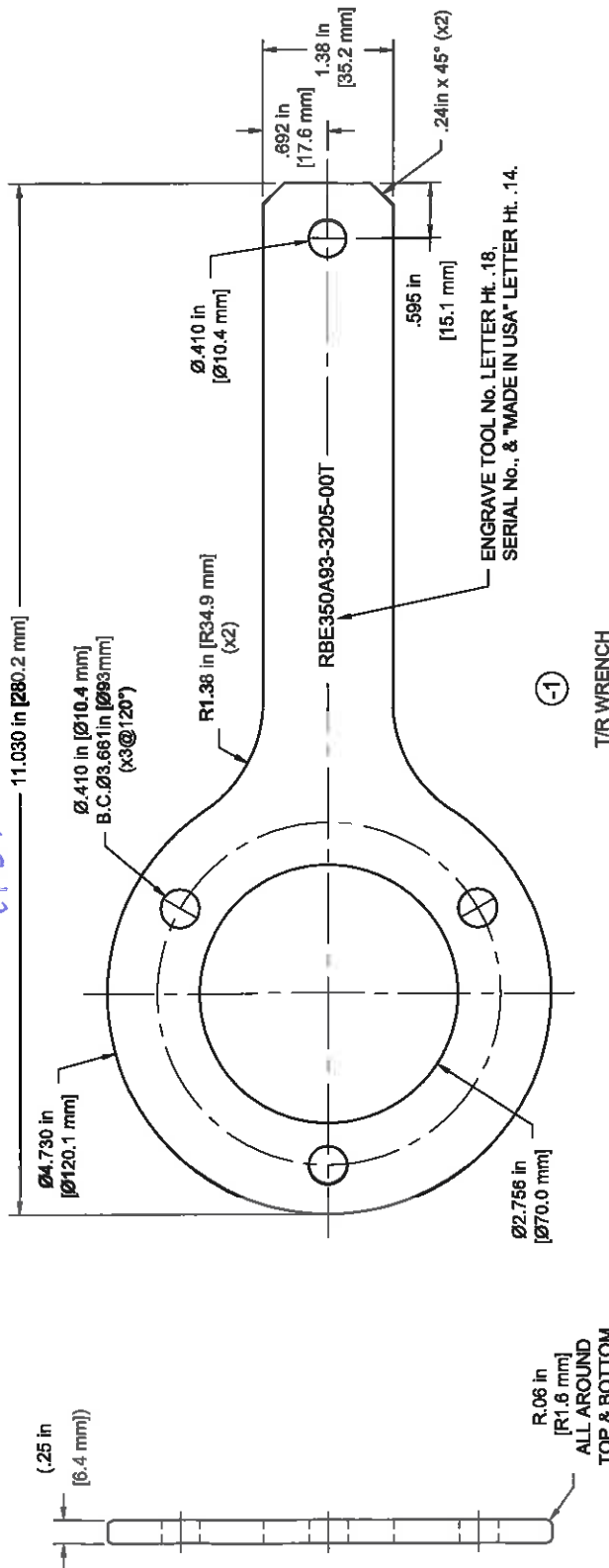
Specifications could not be found.

Plex 7/4/19 3:21 PM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19735445
19-07-05

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL / APPROVED
1	ADDED FLAT WASHER AND CHANGED FROM LOCK NUT TO REGULAR NUT PER SAMPLE. ALSO ADDED ENGRAVING NOTE FOR S/N ECT.	5/12/09	WP
2	CHANGED -01 WRENCH HOLES FROM Ø.410 TO Ø.402 AND HANDLE 236 CHAMFERS TO R.197. ALSO ENLARGED -01 CENTER HOLE FROM Ø2.756 TO Ø2.768 PER HELI PRODUCTS TOOLS. A "T" WAS ADDED TO THE END OF THE TOOL NO. TO IDENTIFY THE DIFFERENCE FROM THE ENGINE FLANGE WRENCH.	9/29/09	WP
3	REMOVED ALL OF REV. 2 CHANGES.	2/17/10	WP
3A	ADDED MISSING R.063 ALL AROUND TOP & BOTTOM DIM. PER G.E. CH'D FLAT WASHER P/N FROM AN960-818 TO AN960-318.	2/19/10	RJC
3B	CORRECTED FINISH SPEC. CH'D BOM FROM -00T TO -1 PER R.W.	2/18/11	RJC
3C	CORRECTED T/N WAS RBE493-3205-00T IS RBE350A93-3205-00T CH'D DIMENSION PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS.	11/5/13	RJC



FUNCTION: USED TO HOLD TGB INPUT
FLANGE DURING INPUT SHAFT NUT
REMOVAL OPERATION.

RED BARN MACHINE

TITLE
TAIL ROTOR GEAR BOX INPUT
FLANGE HOLDING WRENCH

DWG NO.	RBE350A93-3205-00T	REV	3C
DRAWN BY:	PERRITT	APPROVED	2/11/10
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1			
FRACTIONS ± 1/32 ANGLES ± 5°			
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONS UNLESS APPLICABLE PLATING			
SCALE NTS			
DATE 10-22-08 SHEET 1 of 1			

ASSY	BIO	QTY	PART #	DESCRIPTION	MATERIAL	BIO INFORMATION OR SPECIFICATIONS
		1	-1	T/R WRENCH	6061	1/4 x 4-3/4 x 11-1/8
	BIO	3		HEX HEAD CAP SCREW	STEEL	5/16-24 UNF x 31/32 AIRCRAFT SPRUCE #AN5-7
	BIO	3		NUT	STEEL	5/16-24 UNF AIRCRAFT SPRUCE #AN315-5
	BIO	3		FLAT WASHER	STEEL	Ø5/16 I.D. AIRCRAFT SPRUCE #AN960-516



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Other/Details: _____			
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044992**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044992

PO Date: 11/4/19

Due Date: 11/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

2019-11-15

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197351	RBE350A93-3205-00T	RBE350A93-3205-00T Rev 3C	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed X16	-	11/22/19	16 pcs	0 pcs	16 pcs	\$6.63/pcs	\$106.08
2	200357	646.3012	646.3000 Rev NC	Lower Guide : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	11/22/19	28 pcs	0 pcs	28 pcs	\$20.78/pcs	\$581.84
3	202282	D2348	D2348 Rev C	Wearplate (Key Way) : Various STC's Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed X16	-	11/11/19	60 pcs	0 pcs	60 pcs	\$1.83/pcs	\$109.80
4	201033	RBH9928-2	RBH9928-2 Rev K	Trim Tab Bender Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed X10	-	11/11/19	10 pcs	0 pcs	10 pcs	\$6.63/pcs	\$66.30

NOV 15 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044992**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	200996	646.3811	646.3800 Rev A	Radius Block : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	11/22/19	28 pcs	0 pcs	28 pcs	\$7.43/pcs	\$208.04

Grand Total: \$1,072.06

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/19 8:39 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918946

Date: 11-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
16 ea	Part: RBE350A93-3205-00T Tail Rotor Gear Box Input Flan Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils), Water Sealant Job: 26391 PO: POHB044992	Rev: 3C Line: 1	
60 ea	Part: D2348 Wearplate (Key Way) Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils). Job: 26393 PO: POHB044992	Rev: C Line: 3	
10 ea	Part: RBH9928-2 Trim Tab Bender Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 26394 PO: POHB044992	Rev: K Line: 4	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 11 2019</u> Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED
NOV 13 2019
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918946

Date: 11-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		